

# Work Order ID 80412

**\*80412\***

Page 1

February-21-12 9:07:30 AM

Item ID: D2661-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 21/02/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 12/02/21 Tooling:

Run Start **\*NR1\***

QC: Date: SPC (Y/N):

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2661	Rev E								

100

0.00

**\*100\***

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number.

Program part number and batch number  
MACHINE AS PER DWG AND FOLIO FB073

FOLIO REV: E  
DWG REV: E

FK 12/03/05

20 1

BA 12/03/06

PTO →

110

0.00

**\*110\***

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

BA 12/03/06

20 1

FK 12/03/08

W/O: 80412		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2661-1 PAR #: \_\_\_\_\_ Fault Category: machining NCR: Yes No DQA: initial Date: 12/03/16  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 12/3/16

NCR:		WORK ORDER NON-CONFORMANCE (NCR) 186.72						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/03/07	100	1 part scrap → ball mill 1" made a large dimple in the intersection of skid bore and cross-tube bore. → 100% would be out of tolerance after completion. RC. Power <del>stage</del> failure	<u>U</u> 12/03/07	Scrap + Destroy + replace batch #: <u>79587</u>	B.A. 12/03/07	<u>OK</u> 12/03/07	<u>U</u> 12/03/07	<u>S</u> 12/03/07

NOTE: Date & initial all entries

**\*80412\***

Page 2

**\*N900040100\***

Stop **\*NS2\***

**\*20\***

**\*20\***

**Reference:**

Run Start \*NR1\*

Stop **\*NR2\***

**Insp.  
Stamp**

**\*120\***

F.K. 12/03/05

B.A 12/03/06

20

**\*130\***

0.00

20

62

0.00

**\*140\***

0.00

## Hand Finishing

20X  $\phi$  m. / 12/03/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 80412

\*80412\*

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February-21-12 9:07:30 AM

Item ID: D2661-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Saddle, LH Fwd Aft Out 206  
 Start Date: 21/02/2012 Start Qty: 20.00 \*20\* Cust Item ID:  
 Required Date: 06/03/2012 Req'd Qty: 20.00 \*20\* Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo START TIME: 7:15 320P OVEN TEMPERATURE: 7:45 FINISH TIME: M120222	0.00 0.00				20	2	2P BK 12/03/12	
160 *160* QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00				20	4	2P 12/03/12	
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: 435  Memo	0.00 0.00				12/3/12	5P	2P	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 80412****\*80412\***

Page 4

February-21-12 9:07:30 AM

Item ID: D2661-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 21/02/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

12/3/12

12-03-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



# Picklist Print

February-21-12 9:07:34 AM

Page 1

Work Order ID: 80412

\*80412\*

Parent Item: D2661-1

\*D2661-1\*

Parent Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 21/02/2012

Required Date: 06/03/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house  
processEC IPP REV:D  
REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD  
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	127.0000	1	20			

\*D6101-003\*

Saddle Billet, 7075

\*\*

F.K. 12/02/05

Location	Loc Qty	Loc Code
MAT040	63	
73775	2	
73780	7	
78159	19	
78599	28	
MAT041	70	
79587	70	
MAT042	-7	
MAT044	1	
73769	1	

13

7 + 1

12/03/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>				<b>Work Order:</b> 80412	
<b>Description:</b> 206 Saddle, Outboard, Left side				<b>Part Number:</b> D2661-1	
<b>Inspection Dwg:</b> D2661 <b>Rev:</b> E <b>DSK:</b> <b>Rev:</b>				<b>Page 1 of 2</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		0.260	0.260	0.260	0.260	0.260
C	0.315	0.322		0.316	0.316	0.316	0.316	0.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		0.123	0.125	0.125	0.125	0.125
H	0.210	0.230		0.225	0.229	0.228	0.228	0.228
I	0.615	0.685		0.680	0.675	0.675	0.675	0.675
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.323	1.329	1.329	1.329	1.328
L	0.178	0.198		0.188	0.188	0.188	0.188	0.188
M	0.470	0.530		0.500	0.500	0.500	0.500	0.500
N	1.125	1.145		1.134	1.136	1.136	1.136	1.136
O	0.100	0.180		0.135	0.135	0.135	0.135	0.135
P	0.100	0.140		0.132	0.130	0.130	0.131	0.130
Q	0.240	0.260		0.250	0.257	0.257	0.257	0.256
R	0.677	0.697		0.687	0.687	0.687	0.687	0.687
S	0.100	0.140		0.120	0.120	0.120	0.120	0.120
T	1.565	1.585		1.5745	1.575	1.576	1.576	1.576
U	0.540	0.560		0.550	0.550	0.550	0.550	0.550
V	0.912	0.932		0.922	0.922	0.922	0.922	0.922
W	0.787	0.807		0.797	0.797	0.797	0.797	0.797
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AA	0.312	0.319		0.314	0.314	0.314	0.314	0.314
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		0.238	0.238	0.238	0.238	0.238
AG	0.510	0.515		0.512	0.512	0.512	0.512	0.512
AH	0.100	0.120		0.110	0.110	0.110	0.110	0.110
AI								

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	80412
<b>Description:</b> 206 Saddle, Outboard, Left side		<b>Part Number:</b>	D2661-1
<b>Inspection Dwg:</b> D2661 <b>Rev:</b> E <b>DSK:</b> <b>Rev:</b>		<b>Page 2 of 2</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

**Measured by:** FK. / DA 12/03/06 **Date:** 12/03/08

**Audited by:** *cmk* *12/03/09* **Date:** 12/03/09

**Prototype Approval:** **Date:**

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	<i>[Signature]</i>

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	80412
<b>Description:</b> 206 Saddle, Outboard, Left side		<b>Part Number:</b>	D2661-1
<b>Inspection Dwg:</b> D2661 <b>Rev:</b> E <b>DSK:</b> <b>Rev:</b>		Page 1 of 2	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	77	18	19	10
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		0.260	0.260	0.260	0.260	0.260
C	0.315	0.322		0.316	0.316	0.316	0.316	0.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		0.125	0.125	0.125	0.125	0.125
H	0.210	0.230		0.226	0.226	0.226	0.226	0.226
I	0.615	0.685		0.675	0.675	0.675	0.675	0.675
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.327	1.327	1.327	1.327	1.327
L	0.178	0.198		0.188	0.188	0.188	0.188	0.188
M	0.470	0.530		0.500	0.500	0.500	0.500	0.500
N	1.125	1.145		1.136	1.136	1.136	1.136	1.136
O	0.100	0.180		0.135	0.135	0.135	0.135	0.135
P	0.100	0.140		0.132	0.132	0.132	0.132	0.133
Q	0.240	0.260		0.255	0.255	0.255	0.255	0.255
R	0.677	0.697		0.687	0.687	0.687	0.687	0.687
S	0.100	0.140		0.122	0.121	0.122	0.122	0.121
T	1.565	1.585		1.576	1.576	1.576	1.576	1.576
U	0.540	0.560		0.550	0.550	0.550	0.550	0.550
V	0.912	0.932		0.922	0.922	0.922	0.922	0.922
W	0.787	0.807		0.797	0.797	0.797	0.797	0.797
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AA	0.312	0.319		0.314	0.314	0.314	0.314	0.314
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		0.238	0.238	0.238	0.238	0.238
AG	0.510	0.515		0.512	0.512	0.512	0.512	0.512
AH	0.100	0.120		0.110	0.110	0.110	0.110	0.110
AI								

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	80412
<b>Description:</b> 206 Saddle, Outboard, Left side		<b>Part Number:</b>	D2661-1
<b>Inspection Dwg:</b> D2661 <b>Rev:</b> E <b>DSK:</b> <b>Rev:</b>		<b>Page 2 of 2</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

Measured by: B.A	Date: 12/03/06
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Audited by: [Signature]	Date: 12/03/09
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Prototype Approval:	Date:
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Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	[Signature]

<b>DART AEROSPACE LTD</b>				<b>Work Order:</b> 80412	
<b>Description:</b> 206 Saddle, Outboard, Left side				<b>Part Number:</b> D2661-1	
<b>Inspection Dwg:</b> D2661 <b>Rev:</b> E <b>DSK:</b> <b>Rev:</b>				<b>Page 1 of 2</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				#11	#12	#13	#14	#15
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		0.260	0.260	0.260	0.260	0.260
C	0.315	0.322		0.316	0.316	0.316	0.316	0.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		0.125	0.125	0.125	0.125	0.125
H	0.210	0.230		0.226	0.226	0.226	0.226	0.227
I	0.615	0.685		0.675	0.675	0.675	0.675	0.675
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.327	1.327	1.327	1.327	1.327
L	0.178	0.198		0.188	0.188	0.188	0.188	0.188
M	0.470	0.530		0.500	0.500	0.500	0.500	0.500
N	1.125	1.145		1.136	1.136	1.136	1.136	1.1365
O	0.100	0.180		0.135	0.135	0.135	0.135	0.135
P	0.100	0.140		0.132	0.132	0.131	0.131	0.130
Q	0.240	0.260		0.255	0.255	0.255	0.254	0.254
R	0.677	0.697		0.687	0.687	0.687	0.687	0.687
S	0.100	0.140		0.122	0.121	0.122	0.121	0.121
T	1.565	1.585		1.576	1.576	1.576	1.576	1.577
U	0.540	0.560		0.550	0.550	0.550	0.550	0.550
V	0.912	0.932		0.922	0.922	0.922	0.922	0.922
W	0.787	0.807		0.797	0.797	0.797	0.797	0.797
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AA	0.312	0.319		0.314	0.314	0.314	0.314	0.314
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		0.238	0.238	0.238	0.238	0.238
AG	0.510	0.515		0.512	0.512	0.512	0.512	0.512
AH	0.100	0.120		0.110	0.110	0.110	0.110	0.110
AI								

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	80412
<b>Description:</b> 206 Saddle, Outboard, Left side		<b>Part Number:</b>	D2661-1
<b>Inspection Dwg:</b> D2661 <b>Rev:</b> E <b>DSK:</b> <b>Rev:</b>		<b>Page 2 of 2</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

<b>Measured by:</b> D.A. / F.K.	<b>Date:</b> 12/03/07 / 12/03/08
<b>Audited by:</b> <i>cmx</i>	<b>Date:</b> 12/03/09
<b>Prototype Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	<i>[Signature]</i>



<b>DART AEROSPACE LTD</b>				<b>Work Order:</b> 80412	
<b>Description:</b> 206 Saddle, Outboard, Left side				<b>Part Number:</b> D2661-1	
<b>Inspection Dwg:</b> D2661 <b>Rev:</b> E <b>DSK:</b> <b>Rev:</b>				<b>Page 1 of 2</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

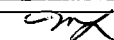
Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				#16	#17	#18	#19	#20
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.260	.260	.260	.260	.260
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.125	.125	.124	.124	.124
H	0.210	0.230		.227	.227	.225	.225	.226
I	0.615	0.685		.675	.675	.675	.675	.675
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.328	1.328	1.324	1.324	1.324
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.1365	1.1365	1.134	1.134	1.134
O	0.100	0.180		.135	.135	.135	.135	.135
P	0.100	0.140		.132	.132	.132	.130	.132
Q	0.240	0.260		.254	.254	.254	.253	.253
R	0.677	0.697		.687	.687	.687	.687	.687
S	0.100	0.140		.122	.122	.122	.122	.122
T	1.565	1.585		1.577	1.577	1.575	1.5745	1.5745
U	0.540	0.560		.550	.550	.550	.550	.550
V	0.912	0.932		.922	.922	.922	.922	.922
W	0.787	0.807		.797	.797	.797	.797	.797
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.500	.499	.500	.500	.498
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.500	.500	.500	.500	.500
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.237	.237	.237	.237	.237
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.110	.110	.110	.110	.110
AI								

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	80412
<b>Description:</b> 206 Saddle, Outboard, Left side		<b>Part Number:</b>	D2661-1
<b>Inspection Dwg:</b> D2661 <b>Rev:</b> E <b>DSK:</b> <b>Rev:</b>		<b>Page 2 of 2</b>	

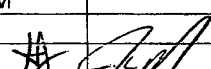
### FIRST ARTICLE INSPECTION DIMENSION SHEET

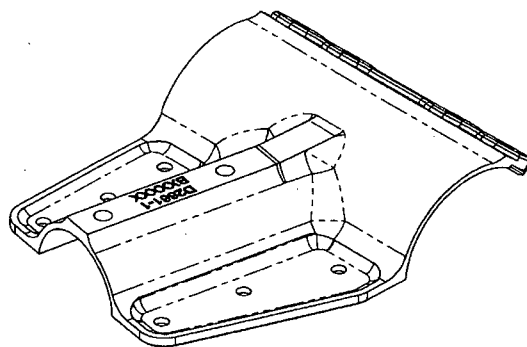
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

**Measured by:** F.H. **Date:** 12/03/08

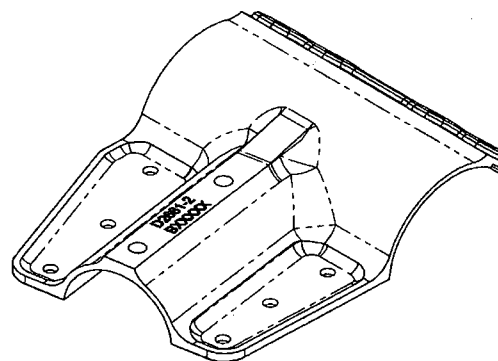
**Audited by:**  **Date:** 12/03/09

**Prototype Approval:** **Date:**

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	



**D2661-1 SADDLE, OUTSIDE, LH**



**D2661-2 SADDLE, OUTSIDE, RH**

80412 M.C.J  
12/02/21

RELEASED  
2011-11-16

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B6-2,B8-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORPORATE DEO 9122, 9102, 9095	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	07.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC. KENT, WA	
DRAWN		DRAWING NO.	REV. E
CHECKED		D2661	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		SADDLE, OUTSIDE	NTS
DE APPR.		COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
DATE	11.10.31		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

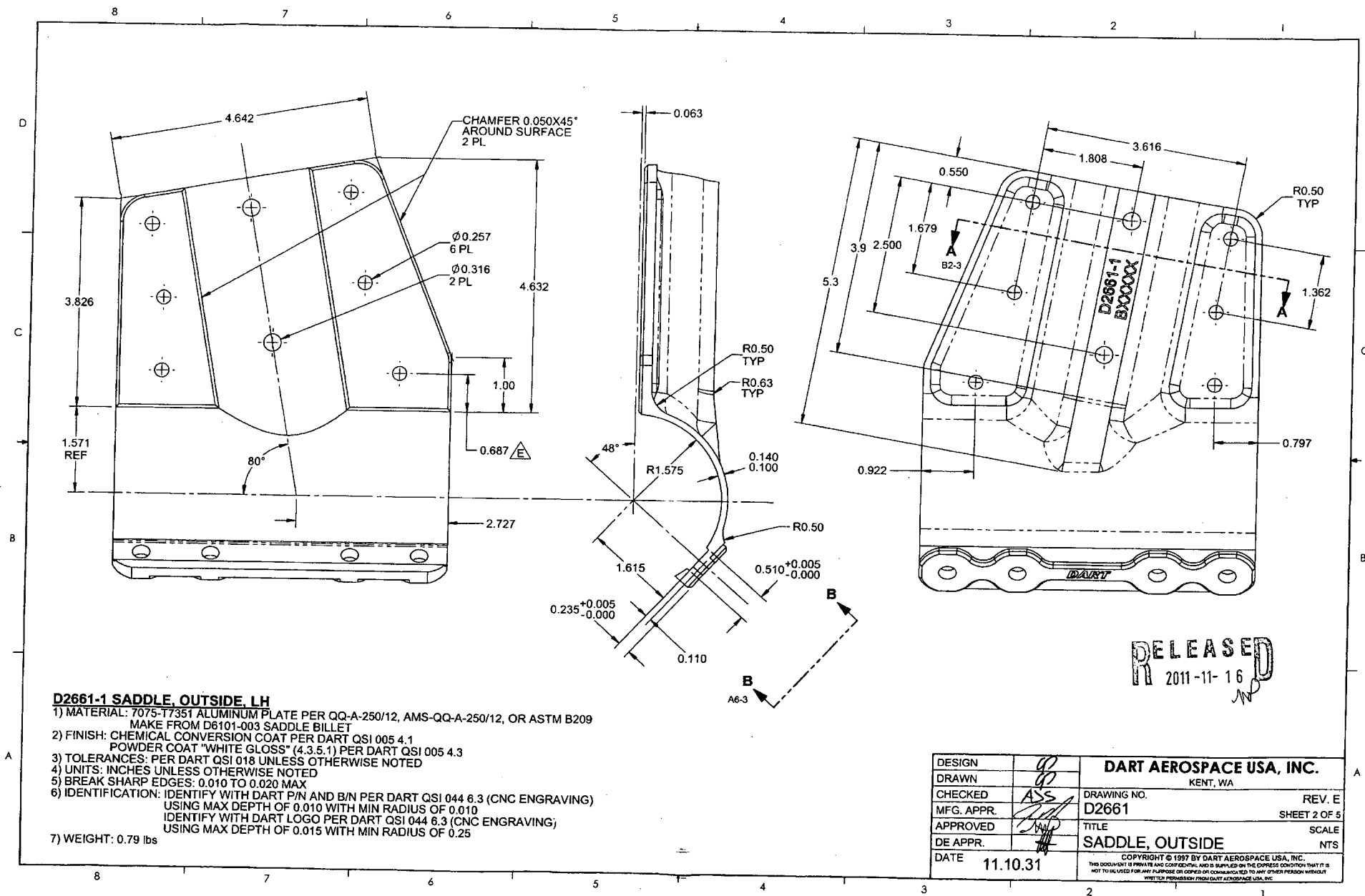
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

80412



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

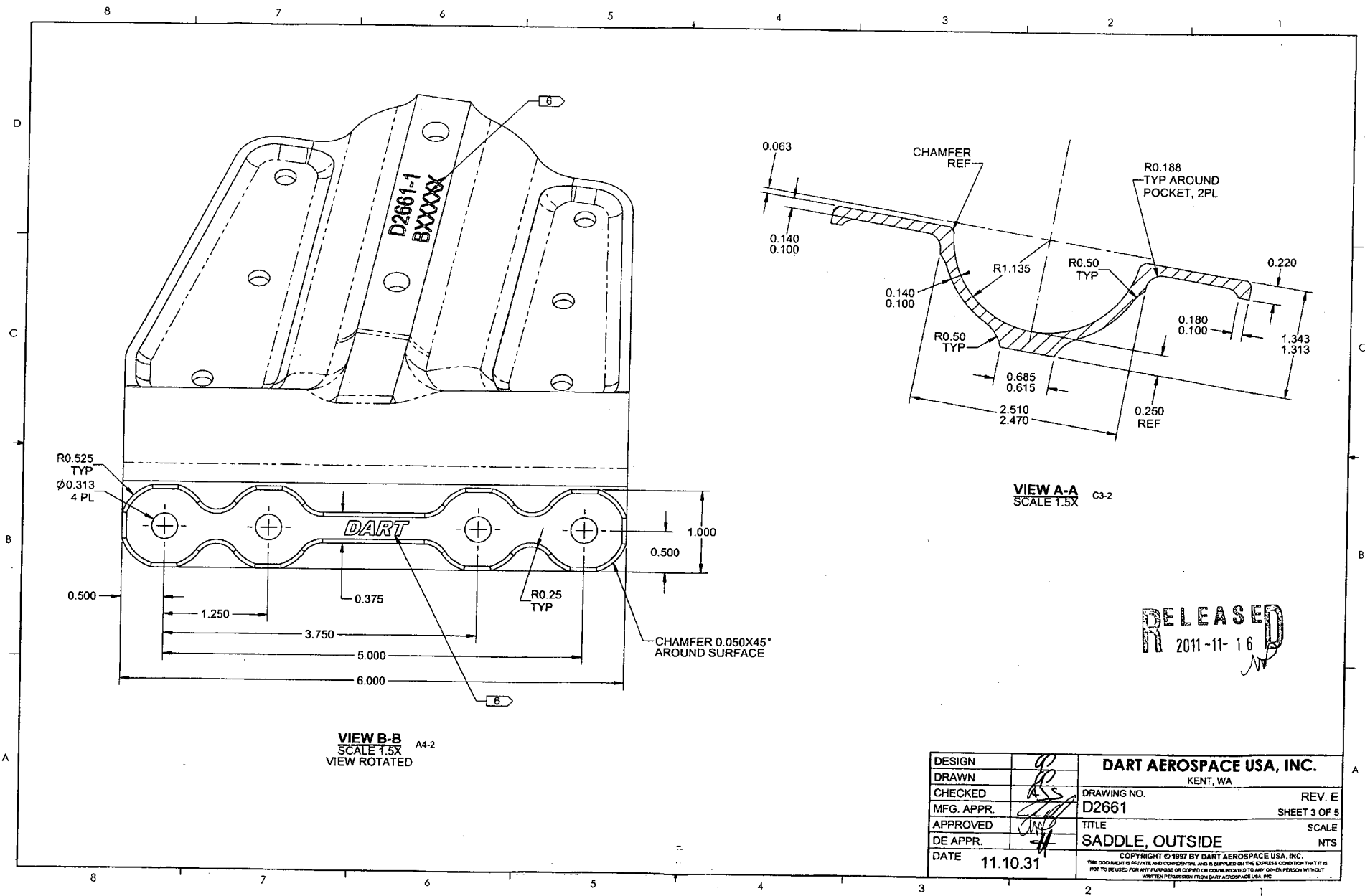
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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R 2011-11-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

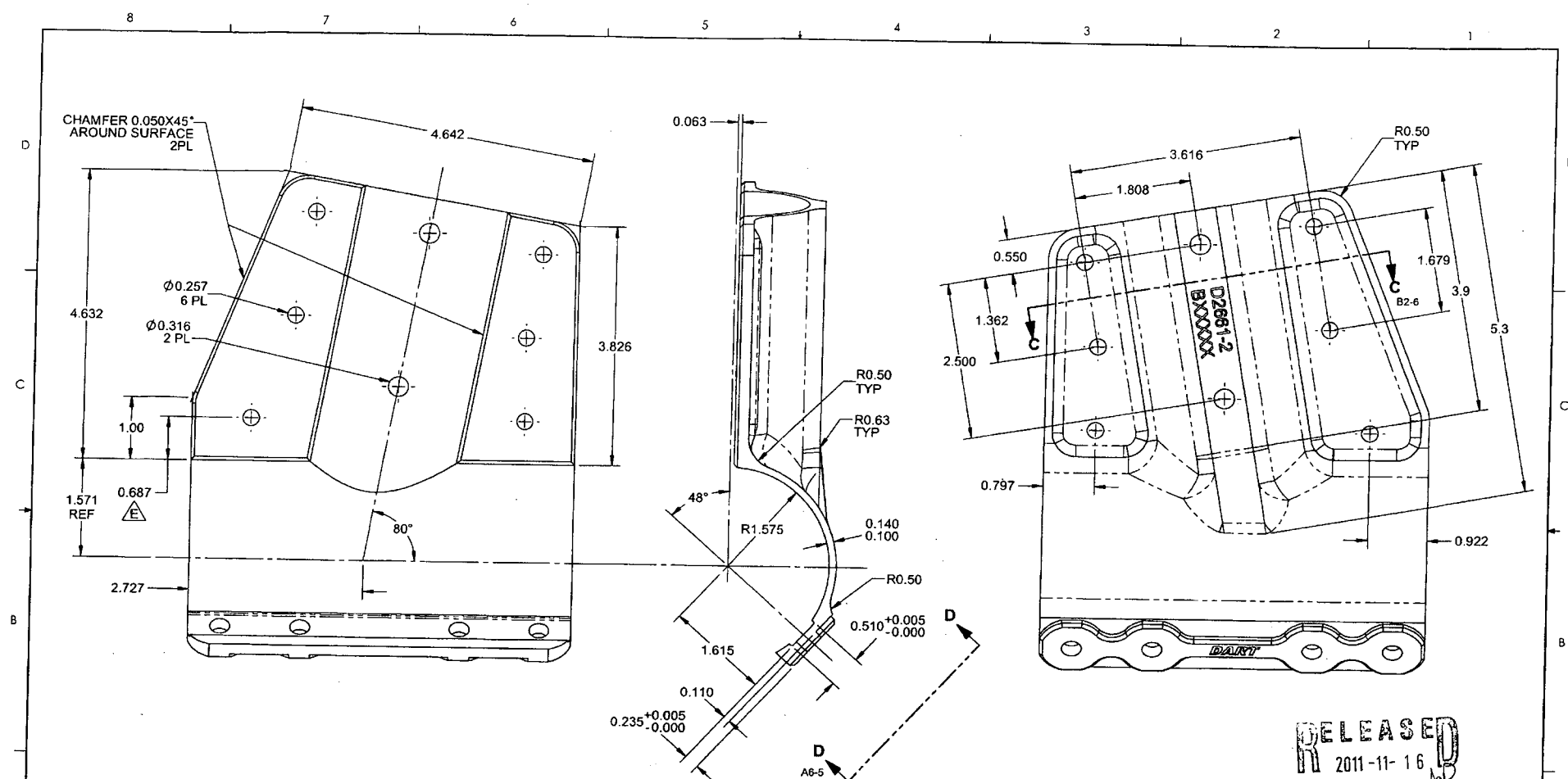
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



80412



RELEASED  
2011-11-16

**D2661-2 SADDLE, OUTSIDE, RH**

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209  
MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)  
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010  
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)  
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, OUTSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

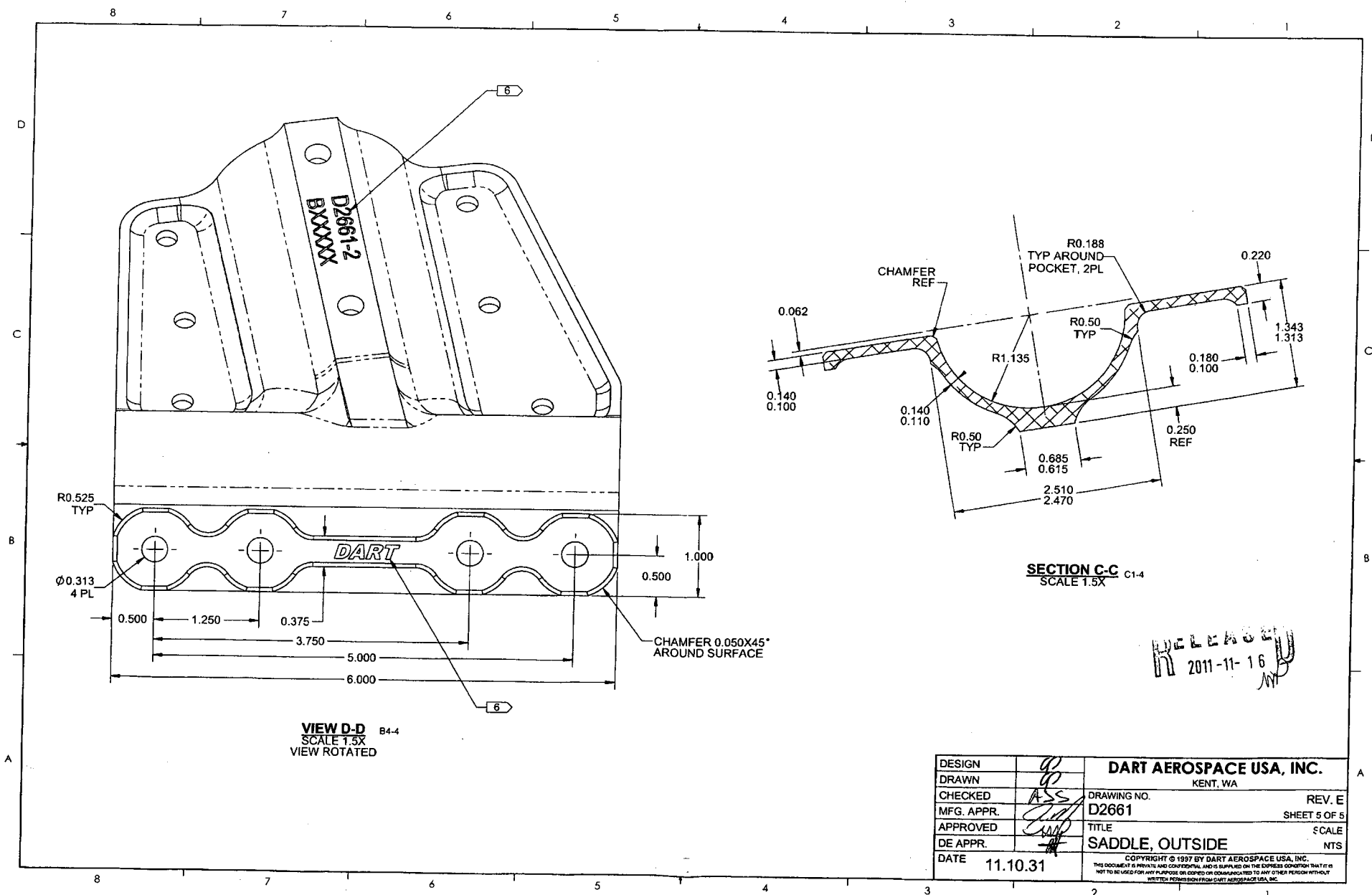
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

80412



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries